

5083572



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4775-1

Job Sheet 177200



Part No: D4775-1

Job Qty: 30 ea

Part Name: Strut Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/6/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C SHEET 2 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B
DD VERF:JLM IPP REV:C 14.01.10 AS PER REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	6/6/18	6/6/18	0.00	0.00	Start Up Machining-3		<i>18/06/24</i>
100	Doosan	30 pcs	6/6/18	6/6/18	0.45	13.22	Doosan		<i>18/06/24</i>
110	QC	30 pcs	6/6/18	6/6/18	0.00	0.00	QC2 Machining-3		<i>18/06/24</i>
120	QC	30 pcs	6/6/18	6/6/18	0.00	0.00	QC8 Machining-3		<i>18/06/25</i>
130	HandFinish	30 pcs	6/6/18	6/6/18	0.00	1.05	HandFinish1		<i>18-06-27</i>
140	QC	30 pcs	6/6/18	6/6/18	0.00	0.00	QC7-4		<i>18-8-4</i>
150	Powdercoat	30 pcs	6/6/18	6/6/18	0.00	0.46	Powdercoat1		<i>18-7-4</i>
155	QC	30 pcs	6/6/18	6/6/18	0.00	0.00	QC3		<i>38</i>
160	Packaging	30 pcs	6/6/18	6/6/18	0.00	0.00	Packaging3-2	<i>ST 357</i>	<i>JUL 05 2018</i>
170	QC21-SA	30 Ea	6/6/18	6/6/18	0.00	0.00	QC21	<i>21</i>	<i>JUL 05 2018</i>

Part Op 100 - 1- Turn as per Folio FB166 Rev: *AA* & Dwg D4775 Rev: *C* 2- Tap for 3/8-24 Helical insert check with GO/
Descriptions: NO GO gauge 3

150 - START TIME: *10:15 O.U.T. 300° FINISH: 10:45. M.B. 4839.*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.625W.125	6061-T6 Round Tube 0.625 X.125W	32.7000 ft (1.09 ea)	90-Start up Operation	<i>5072327</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.625W.125	33	25	0

Part Specifications

Specifications could not be found.

Plex 5/8/18 10:32 AM Dart.Gagnon.Michelle

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering																																																																																																																																			
Part No. _____		Rework		Cross tube				Water Jet																																																																																																																																			
NCR No. _____		Scrap		Small Fab				Prod. Eng. Coord.																																																																																																																																			
		Use-as-is		Finishing				Rec/Store/Packaging																																																																																																																																			
		Suspected Unapproved		Composite				Supplier																																																																																																																																			
Date: _____		Step #: _____		QTY Effective: _____				MRB (QS1042) Approval																																																																																																																																			
Description Work Order Deviation				Disposition																																																																																																																																							
<table border="1"> <tr> <th colspan="10">Root Cause</th> </tr> <tr> <td>Environment</td> <td>No Re-verification</td> <td>Pressure/Forced</td> <td colspan="7"></td> </tr> <tr> <td>Design</td> <td>Operator</td> <td>Bending</td> <td colspan="7"></td> </tr> <tr> <td>Doc/Data</td> <td>Offset/Setup</td> <td>Centre Not Concentric</td> <td colspan="7"></td> </tr> <tr> <td>Equip/Tooling</td> <td>Supplier</td> <td>Cracks</td> <td colspan="7"></td> </tr> <tr> <td>Handling/Pre</td> <td>Training</td> <td>Crimp/Kink/Ripple/Wave</td> <td colspan="7"></td> </tr> <tr> <td>Material</td> <td>Use for Testing</td> <td>Cuffs</td> <td colspan="7"></td> </tr> <tr> <td>Internal Transport</td> <td>Poor Information</td> <td>Crushing</td> <td colspan="7"></td> </tr> <tr> <td>Tribal Knowledge</td> <td>Rushing</td> <td>Heat Treat</td> <td colspan="7"></td> </tr> <tr> <td>LOA</td> <td>Product Improvement</td> <td>Wave/Twist in Tube</td> <td colspan="7"></td> </tr> <tr> <td>Substation</td> <td>Process Improvement</td> <td>Marks/Chatter</td> <td colspan="7"></td> </tr> <tr> <td>Past Expiry Date</td> <td>Manufacturing Process</td> <td>OTHER :</td> <td colspan="7"></td> </tr> <tr> <td>Misidentified</td> <td>Past Due</td> <td></td> <td colspan="7"></td> </tr> </table>										Root Cause										Environment	No Re-verification	Pressure/Forced								Design	Operator	Bending								Doc/Data	Offset/Setup	Centre Not Concentric								Equip/Tooling	Supplier	Cracks								Handling/Pre	Training	Crimp/Kink/Ripple/Wave								Material	Use for Testing	Cuffs								Internal Transport	Poor Information	Crushing								Tribal Knowledge	Rushing	Heat Treat								LOA	Product Improvement	Wave/Twist in Tube								Substation	Process Improvement	Marks/Chatter								Past Expiry Date	Manufacturing Process	OTHER :								Misidentified	Past Due								
Root Cause																																																																																																																																											
Environment	No Re-verification	Pressure/Forced																																																																																																																																									
Design	Operator	Bending																																																																																																																																									
Doc/Data	Offset/Setup	Centre Not Concentric																																																																																																																																									
Equip/Tooling	Supplier	Cracks																																																																																																																																									
Handling/Pre	Training	Crimp/Kink/Ripple/Wave																																																																																																																																									
Material	Use for Testing	Cuffs																																																																																																																																									
Internal Transport	Poor Information	Crushing																																																																																																																																									
Tribal Knowledge	Rushing	Heat Treat																																																																																																																																									
LOA	Product Improvement	Wave/Twist in Tube																																																																																																																																									
Substation	Process Improvement	Marks/Chatter																																																																																																																																									
Past Expiry Date	Manufacturing Process	OTHER :																																																																																																																																									
Misidentified	Past Due																																																																																																																																										
DART AEROSPACE Container No: S083573 Part: D4775-1 Job No: 177200 Serial No/Batch: S083573 Revision: Inspector: Exp Date: Instructions: Date: 06/24/10																																																																																																																																											
Lead hand / Supervisor Approval Verification Completed By																																																																																																																																											

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com